

117 b2shet

Work Order ID 98625

March-15-13 2:20:14 PM

98625

PRIMARY ISSUE

Page 1

Item ID: D4150-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Attachment Arm Assembly
Start Date: 3/15/13 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/19/13 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4150	pc1								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location:	0.00							
120									
Packaging	Memo	0.00							
Packaging									

14

4/13/13/18

133 19

1
inspected on per
Dwg PC1

Work Order ID 98625***98625***

Page 2

March-15-13 2:20:14 PM

Item ID: D4150-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Attachment Arm Assembly

Start Date: 3/15/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/19/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MF
13-4-21

Picklist Print

March-15-13 2:20:13 PM

Page 1

Work Order ID: 98625

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 3/15/13

Required Date: 3/19/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A Bolt		Purchased	No			100	Each	59.0000	2	2		3/13/03/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		59				2			
				122639		59							
D4150-1 Arm		Manufactured	No			100	Each	18.0000	1	1		3/13/03/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST145		18							
				93348		18				+	98626		
D4150-3 Arm Plate		Manufactured	No			100	Each	22.0000	2	2		3/13/03/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST145		22				2			
				93831		2							
				95929		20							
MS21043-3 Nut		Purchased	No			100	Each	2,943.0000	2	2		3/13/03/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		80							
				103691		80							
				GA		106							
				123899		106							
				ST315		2757							
				123899		196							
				124555		2561				2			

Picklist Print

March-15-13 2:20:13 PM

Page 2

Work Order ID: 98625

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 3/15/13

Required Date: 3/19/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

9,529.0000

4

4

Washer

Location

Loc Qty

Loc Code

FP001

264

123355

264

ST292

4265

123248

18

123759

4247

ST517

5000

124580

5000

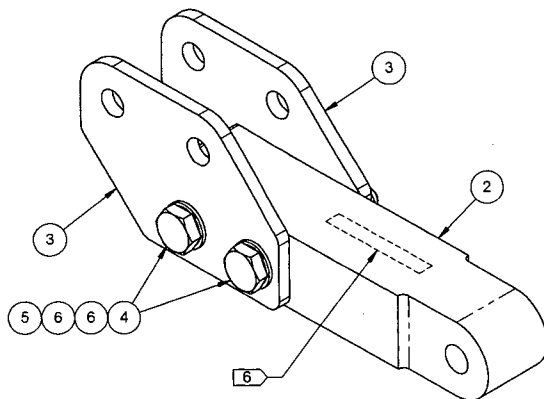
4
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PS 3/23/18

March-15-13 2:20:13 PM

Shop Packet Print

Page 2



D4150-041 ATTACHMENT ARM ASSY

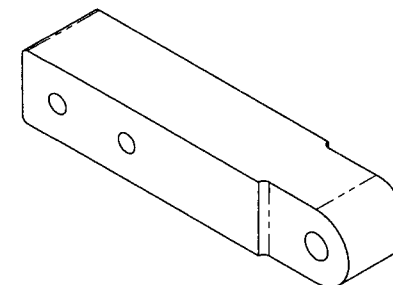
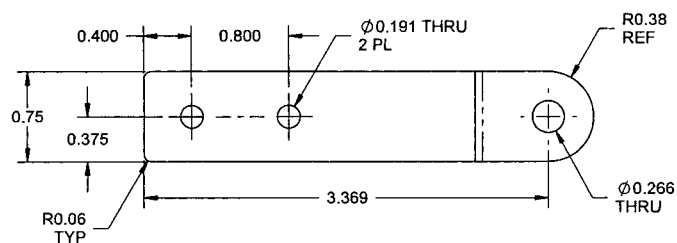
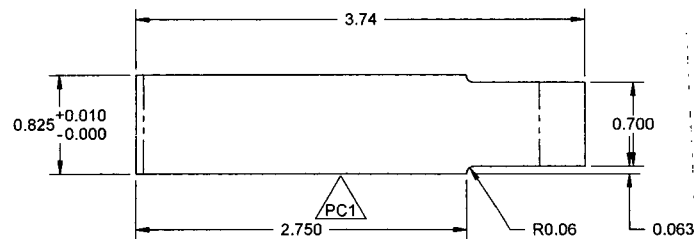
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.84 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4150-041	ATTACHMENT ARM ASSY
2	1	D4150-1	ARM
3	2	D4150-3	ARM PLATE
4	2	AN3C13A	BOLT
5	2	MS21043-3	NUT
6	4	NAS1149C0332R	WASHER

PC1	2.750 WAS 2.907 (ZN C6-2)	RF	13.03.15
B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C6-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4150 REV. PC1 SHEET 1 OF 3 ATTACHMENT ARM ASSY SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
CHECKED	RF		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.03.15		

WLO 98625

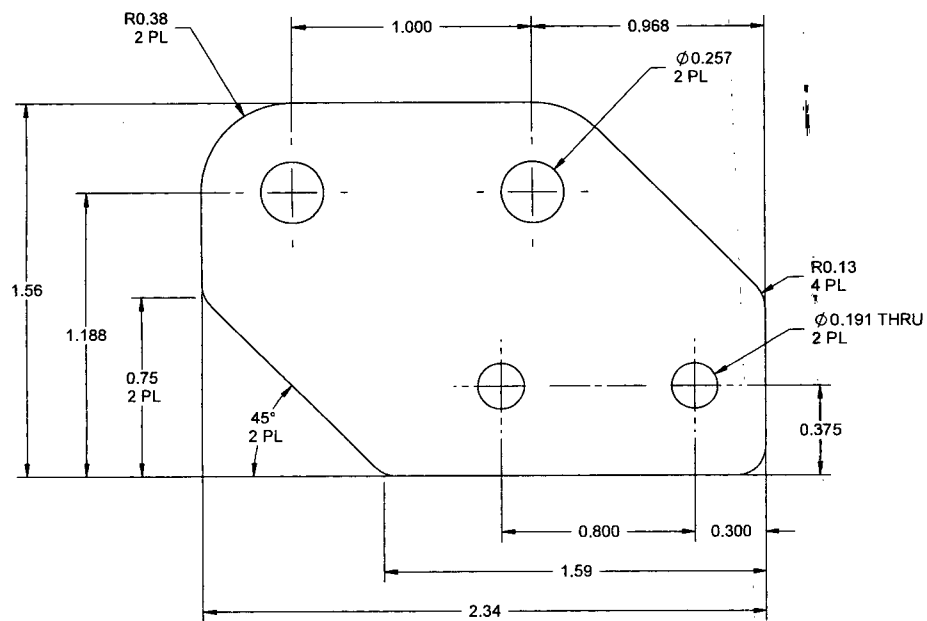


D4150-1 ARM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. PC1
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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D4150-3 ARM PLATE

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. PC1
MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	13.03.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

